

Work Order ID 83500

83500

Page 1

Thursday, April 19, 2012 10:23:11 AM

Item ID: D350-589-011

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Side Door Latch Modification

Start Date: 4/19/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/27/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date: 12-04-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
INN-D350-589	E								
100	DOCUMENT CONTROL	0.00							
100									
DC	Memo	0.00							
Document Control	Photocopy blue file and type label as per PPP D350-589-011 CHG002								
105	Pick Kit	0.00							
105									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
110									
QC	Memo	0.00							
Quality Control									

JB 8/2/16

JB 8/2/16 12-5-16
(5)

5 12/05/16 JB
(5)

(45)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83500***83500***

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Required Date: 4/27/2012 Req'd Qty: 5.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
120									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per QSI 014								
	<i>Revc</i>								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12-05-17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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83500

D350-589-011

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP F02.08.29Removed D2587 PlugKJ
ALL AT CHANGE 002

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN960JD10 *AN960JD10*	NAS1149D0363J	Purchased		No		105	Each	0.0000	3	15	✓		
Washer D2237 *D2237*		Manufactured		No		105	Each	46.0000	3	15	✓		
Striker Plate													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST006			46					
					66139			1					
					82062			45		82062			
D2583 *D2583*		Manufactured		No		105	Each	33.0000	3	15	✓		
Latch Bracket													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST011			33					
					82070			33		82070			
D2585 *D2585*		Manufactured		No		105	Each	29.0000	3	15	✓		
Mounting Channel													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST011			29					
					73297			2					
					78805			27		12X 78805			

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Picklist Print

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Thursday, April 19, 2012 10:23:16 AM

Work Order ID: 83500

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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

D2586 Manufactured No

105 Each

68.0000

15

**

JB



D2586

Door Latch

Location

Loc Qty

Loc Code

ST203A

68

77697

18

78833

50

105 Each

37.0000

5

**

JB



D2587

Manufactured No

D2587

Door Slug, 350 Hinge

Location

Loc Qty

Loc Code

ST011

37

74522

1

78893

36

105 Each

5.0000

5

**

JB



D2589

Manufactured No

D2589

Keys, Key Chain, 350 Hinge

Location

Loc Qty

Loc Code

ST011

5

58194

5

105 Each

2,083.000

30

**

JB

12/05/16



MS20470AD4-5

Purchased No

MS20470AD4-5

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2083

118405

732

120142

1351

120142

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Parent Item: D350-589-011

D350-589-011

Parent Item Name: Side Door Latch Modification

Start Date: 4/19/2012

Required Date: 4/27/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L3

Purchased

No

105

Each

2,849.000

15

MS21042L3

Nut

**

JB

SP

Location

Loc Qty

Loc Code

ST300

2849

117441

16

117885

32

118451

5

118927

3

119017

1635

119075

158

121349

1000

MS27039-1-15

Purchased

No

105

Each

89.0000

15

MS27039-1-15

Screw

**

JB

12/05/16

Location

Loc Qty

Loc Code

ST291

89

118093

12

118574

2

119736

25

121243

50

9x 119736
6x 121243

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

REFERENCE ONLY

52.4 PARTS LIST

589 -011	589 -041	589 -042	589 -043	Part Number	Description
X				D350-589-011	SIDE DOOR LATCH MODIFICATION KIT
	X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
		X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
			X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
	1			D2991-1	Door
		1		D2991-2	Door
			1	D2991-3	Door
/ 3	3	3	3	D2237	Striker Plate
	1	1	1	D2464-1700	Seal
/ 3				D2583	Latch Bracket
/ 3	3	3	3	D2585	Latch Clamp
3	3	3	3	D2586	Latch
1				D2587	Plug
1	1	1	1	D2589	Keys, Key Chain
	3	3	3	D2621	Latch Plate
	2**	2**	2**	D2992-1	Doubler
	1	1	1	D3085-041	Prop Assembly
	1*	1*	1*	D3015-3	Locknut
	1*	1*	1*	D3081-1	Prop Hinge
	1*	1*	1*	D3082-1	Clip
	1*	1*	1*	D3084-1	Prop Arm
	1*	1*	1*	AN4-5A	Bolt
	3*	3*	3*	AN960JD10	Washer
	3*	3*	3*	AN960JD10L	Washer
	2*	2*	2*	AN960JD416	Washer
	1*	1*	1*	AN960JD516L	Washer
	3*	3*	3*	MS21042L3	Nut (or MS21042-3)
	1*	1*	1*	MS21042L4	Nut (or MS21042-4)
	3*	3*	3*	MS27039-1-13	Screw
	1*	1*	1*	SL69-BS	Ball Stud
	6	6	6	AN3-4A	Bolt
3	3	3	3	AN960JD10	Washer
3	9	9	9	MS21042L3	Nut (or MS21042-3)
6	6	6	6	MS20470AD4-5	Rivet
3	3	3	3	MS27039-1-15	Screw

* Reference only. Included in D3085-041 Prop Assembly listed above.

** Reference only. Included in D2991-1/-2/-3 Doors listed above.

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52-00-00